

Date: Friday, 10/5/2007 10:58:49 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INNER FWD SADDLE
Job Number : 35034	
Estimate Number : 11079	
P.O. Number :	Part Number : D5953
This Issue : 10/5/2007 S.O. No. :	Drawing Number : D5953 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 32301	Material :
Written By :	Due Date : 10/22/2007 Qty: 8 Um: Each
Checked & Approved By : <i>[Signature]</i> 07/10/05	
Comment : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:f ecn 826 06.12.06 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)  
 D6101-007(7075-T7351)  
 Size 2.50" x 7.50" X 8.25" (Grain along 7.50")  
 Batch: *131389*

*J.F. 07/10/31*

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5953, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

*J.L. / J.F. 07/10/31*

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

*J.L. / J.F. 07/11/04*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*J.F. 07/11/04*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

*J.F. 07-11-05*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 10/5/2007 10:58:49 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER FWD SADDLE

Job Number: 35034

Part Number: D5953

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m/05914



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FD 07/11/06 (8)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m/

07/14/06

(8x)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 421

(8x)

AS

07/11/06

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.07

JA

Job Completion



Le 07-11-07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	35034
<b>Description:</b> Inner Fwd Saddle		<b>Part Number:</b>	D5953
<b>Inspection Dwg:</b> D5953	<b>Rev:</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.439	0.438	0.439	.441		
B	1.745	1.755		1.750	1.750	1.749	1.750		
C	5.245	5.255		5.249	5.250	5.248	5.250		
D	6.995	7.005		6.998	7.001	6.998	6.999		
E	5.745	5.755		5.749	5.750	5.750	5.750		
F	4.745	4.755		4.749	4.748	4.747	4.748		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.523	1.526	1.526	1.526		
I	3.048	3.058		3.049	3.053	3.053	3.053		
J	4.575	4.585		4.579	4.580	4.580	4.580		
K	0.313	0.318		.319	.318	.319	.319		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.505	.504	.502	.502		
N	1.615	1.635		1.624	1.624	1.624	1.624		
O	7.990	8.010		8.002	8.005	8.004	8.004		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.312	.310	.310	.310		
R	0.760	0.765		0.762	.762	.762	.762		
S	0.490	0.510		0.499	.499	.502	.500		
T	1.375	1.395		1.386	1.386	1.386	1.386		
U	2.000	2.020		2.001	2.001	2.001	2.001		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RF
Date:	07/10/31

Audited by:	J.F.
Date:	07/11/04

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	35034
<b>Description:</b> Inner Fwd Saddle		<b>Part Number:</b>	D5953
<b>Inspection Dwg:</b> D5953	<b>Rev:</b> B	<b>Page 1 of 1</b>	

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D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.525	1.526	1.527	1.562		
I	3.048	3.058		3.052	3.053	3.053	3.053		
J	4.575	4.585		4.577	4.579	4.579	4.579		
K	0.313	0.318		.319	.319	.319	.319		
L	0.495	0.505		.502	.500	.499	.499		
M	0.490	0.510		.501	.499	.501	.560		
N	1.615	1.635		1.625	1.624	1.628	1.630		
O	7.990	8.010		8.000	8.002	8.001	8.001		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.502	.500	.498	.502		
T	1.375	1.395		1.386	1.385	1.385	1.393		
U	2.000	2.020		2.001	2.000	2.000	2.003		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

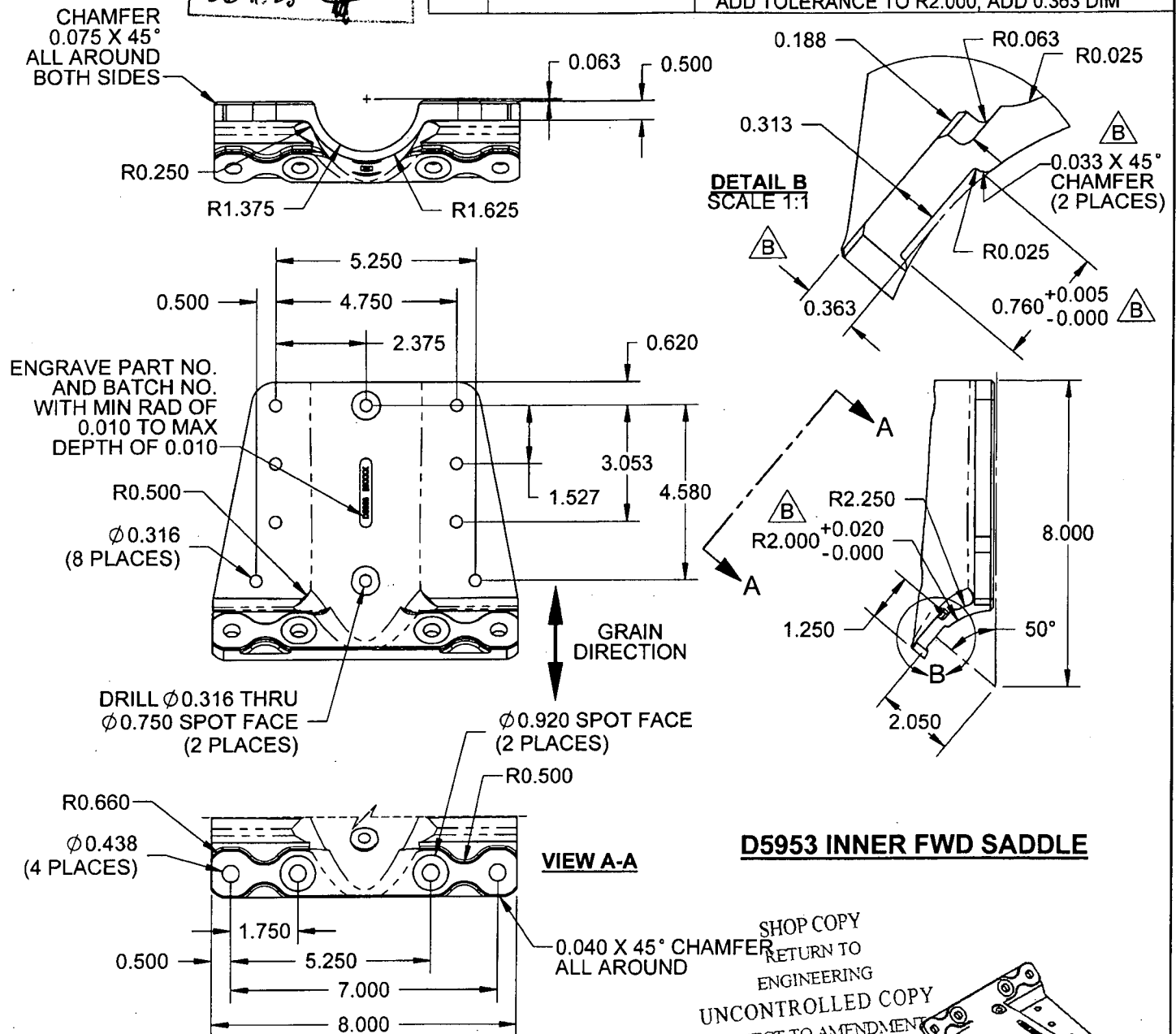
Measured by:	J.L.
Date:	07/11/04

Audited by:	J.F.
Date:	07/11/04

Rev	Date	Change	Revised by	Approved
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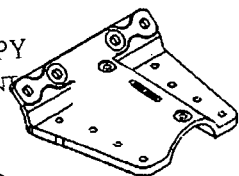
**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5953</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>INNER FWD SADDLE</b>		SCALE 1:4
REV <b>A</b>	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>	
<b>B</b>	<b>06.11.07</b>	<b>INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM</b>	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **35034**



**ISOMETRIC VIEW**  
SCALE 1:8

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